



An Alco Industries Company  
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ProSprayFinishes.com • ProSprayH2O.com



# TECHNICAL DATA SHEET

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## H2O Waterborne Basecoat

Technical Support: 1-800-776-0933

**Product Description** The Pro-Spray® H2O Waterborne Basecoat System makes converting to VOC compliance easy. Our compact assortment of toners, binders and thinners deliver solids, metallics, xirallics and pearlescents that provide excellent sprayability, coverage, color match and blends. No special mix bank equipment is needed and mixing is simple; just shake and pour. H2O revolutionizes refinishing with a VOC-compliant system that maintains a high quality finish without affecting productivity. Pro-Spray H2O - The ultimate in waterborne refinishing technology and value.

Pro-Spray H2O Waterborne Basecoat is supported by a complete line of compliant primers, clearcoats, accessory products and color tools.

**NOTE:** Shake toners by hand before adding pour spout and placing on mixing bank.

### Components



**Basecoat Thinner**      **Pro-Spray H2O Basecoat Color**  
**HTH-150™ (Normal) or HTH-300™ (Fast)**

### Typical Substrates

Apply Pro-Spray H2O mixed color only over:

- Two-component primer (properly prepped)
- 2K Sealer for H2O
- Prepared existing paintwork in sound condition

**NOTE:** Do not apply H2O basecoats directly over polyester primer, electro coat, 1K and 2K etch primer or TPA finishes. Always topcoat these finishes with 2K urethane primer or sealer before applying waterborne basecoat.

### Surface Preparation



Apply over properly prepared and applied two-component primer, OE finish or existing finish. Wet sand with P600–P800 grade abrasive or DA sand with P500-P600 grade abrasive. Allow wet sanded surface to dry thoroughly. Carefully clean surfaces with ICR-0020™, ICR-0014™ or ICR-0010™ surface cleaners to remove all dust, sanding residues, water soluble salts and other impurities. Wipe surface with a lint-free cloth and allow to dry completely before applying color.

**Blend Areas:** Clean surface with ICR-0020/0014/0010 to remove any contaminants. Allow to dry then abrade with an ultrafine scuff pad. Carefully clean surfaces with ICR-0020/0014/0010 surface cleaners to remove all dust, sanding residues, water soluble salts and other impurities. Wipe surface with a clean, lint-free cloth and allow to dry completely before applying color.

**NOTE:** New electro coat panels must be coated with a two-component primer or sealer before applying topcoat color. All primer must be sanded, cleaned and thoroughly dried before topcoat is applied.

### Color Mixing

Mixed from Pro-Spray H2O mixing toners using the formulas on the Pro-Spray Color Software. Shake the tinter components for a few seconds by hand before use; do not mechanically shake. Hand-stir mixed colors immediately after weighing. Mix paint only in plastic containers. **DO NOT** use metal cans. Always strain with nylon paint filters (190 micron) designed specifically for use with waterborne paints.

### Mix Ratio

	<u>Basecoat &amp; Groundcoat</u>	<u>Tinted Midcoat</u>
<b>Basecoat Thinner</b>	1 Part up to 10%	1 Part up to 15%

### Pot Life @ 72°F / 22°C

 1 month

### Viscosity @ 72°F / 22°C

<b>Solid &amp; Metallic:</b>	23–28 secs DIN4
<b>Groundcoat:</b>	23–32 secs DIN4
<b>Tinted Midcoat:</b>	13–15 secs DIN4

# H2O Waterborne Basecoat

## Gravity Gun Set Up



**High Efficiency or HVLP:** 1.2mm–1.3mm  
**NOTE:** Smaller fluid tip (1.1mm) may be used with touch up guns for small areas or extreme cool temperatures. Larger fluid tip (1.4mm and up) may be required for high temperature, low humidity environments.

## Air Pressure



For pressure recommendations on compliant guns, refer to the gun manufacturer's usage information.

## Application



### Solid & Metallic Basecoat

1 light coat  
1 medium coat  
1 light control coat

### Three-Stage Ground Coat

1 light coat  
2 medium coats

### Three-Stage Tinted Mid-coat

Apply single coats until a blendable match is achieved. Blend mid-coat as necessary.

- Depending on color, additional coats may be necessary. **DO NOT** apply more coats than necessary for coverage.
- Allow to flash fully between coats.

**Fade out Process** Apply basecoat to opacity over properly prepped and primed areas. Adhere to flash and dry times. Next, reduce mixed color 30–50% with *HFO-100™ Fade Out Additive*. With air pressure set to 16 - 25 psi (1.1–1.7 bar), apply light coats of reduced color, extending each coat past the edges of the previous coat. Use an arcing motion at the end of each pass while maintaining constant pressure. Apply clearcoat to the entire area after the basecoat has fully dried.

## Dry Times @ 72°F / 22.2°C



### **Air Dry & Baking:**

After each coat of H2O and/or before applying a clearcoat, allow basecoat to flash off until the surface has dried to a matte finish.

**Short Wave & Medium Wave:** 3–5 minutes. Will be matte finish when dry.

**NOTE:** After 6 hours, sand with P600 grit or finer, or scuff pad, and reapply basecoat.

## Topcoats

When uniformly dry, topcoat with:

- In U.S. National Rule regulated areas: topcoat with any Pro-Spray Clearcoat
- In Low VOC regulated areas: topcoat with any low 2.1 VOC Pro-Spray Clearcoat

## Special Notes / Clean Up



### **Clean Up DO NOT USE CLEANING EQUIPMENT OR SOLVENTS USED TO CLEAN NORMAL SOLVENTBORNE PRODUCTS.**

Clean equipment after use with **H2O GUN CLEANER (HGC-120™)**. Disassemble gun, unscrew cups and filter (if fitted), and rinse separately. Rinse gun thoroughly with water. Assemble gun and spray **HGC-120** through the gun to completely clean the gun and spray components. Follow automatic gun cleaning machine process included in instruction manual. Dispose of solvent according to state, local and federal regulations.

**DO NOT FREEZE! Store at room temperature in a clean, dry area.**

## Physical Data – Mixed Color

**VOC (RTS) per U.S. Gal (1:10%) Coverage / US Gal (RTS)**

**Less Exempt:** 1.83–3.12 Lbs (Max VOC)  
423–847 sq. ft. / U.S. gallon @ 1 mil

**Actual:** .58–.75 lbs (Max VOC)

## Health and Safety



For professional use only. KEEP OUT OF REACH OF CHILDREN. WARNING! CONTENTS ARE FLAMMABLE. VAPOR AND SPRAY MIST IS HARMFUL. SKIN AND EYE IRRITANT.

Do not handle the Pro-Spray products until the Material Safety Data Sheets have been read and understood in their entirety. Ensure that all employees are trained on Material Safety Data Sheets and all chemicals with which they come into contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist. Wear protective clothing, gloves and eye safety with a side shield.

This data sheet information is given in good faith but without warranty. The information contained herein represents the current state of our knowledge and is intended as a guide to our products and their uses; it is not intended for insurance of certain product properties or of their specific applications.

Follow all warnings on product labels.